

Work Order ID 55112

January 6, 2010 2:13:30 PM

Page 1

Item ID: D3822-3KIV

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel, Aft Center-Ivory

Start Date: 1/06/10 Start Qty: 1.00

Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

110

0.00

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA027 using tool DT9072
Dwg Rev: C
Folio Rev: A

BB
10/21/27
X1

BB
10/21/27
X1

Work Order ID 55112

January 6, 2010 2:13:31 PM



Page 2

Item ID: D3822-3KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Aft Center-Ivory

Start Date: 1/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

B
10/01/27
(X1)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Ch. 10/01/27
(X1)

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

Ch. 10/01/27
K1

Work Order ID 55112

January 6, 2010 2:13:31 PM



Page 3

Item ID: D3822-3KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Aft Center-Ivory

Start Date: 1/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Complete FAI document	0.00							DH-10/01/27 x1
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							27 S.10.01.25 ⑦0
170 	Identify as per dwg & Stock Location: <u>4/A1</u>	0.00							
Packaging Packaging	Memo	0.00							10-1-28 RSP

Work Order ID 55112

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Page 4

Item ID: D3822-3KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Aft Center-Ivory

Start Date: 1/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/29 *[Signature]*
UMF 10-1-28

00700Jan

Picklist Print

January 6, 2010 2:13:29 PM

Page 1

Work Order ID: 55112



Parent Item: D3822-3KIV



Parent Item Name: Vertical Tunnel, Aft Center-Ivory

Start Date: 1/06/10

Required Date: 1/11/10

Comments: Est Rev:C Add Colour Code 09-06-02 DL

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	790.9390	5.2526			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

790.9390153

109703

790.939015

7.8 sq ft

10/01/27
X1

DART AEROSPACE LTD		Work Order: 55117
Description: Vertical Tunnel, Aft Center		Part Number: D3822-3KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

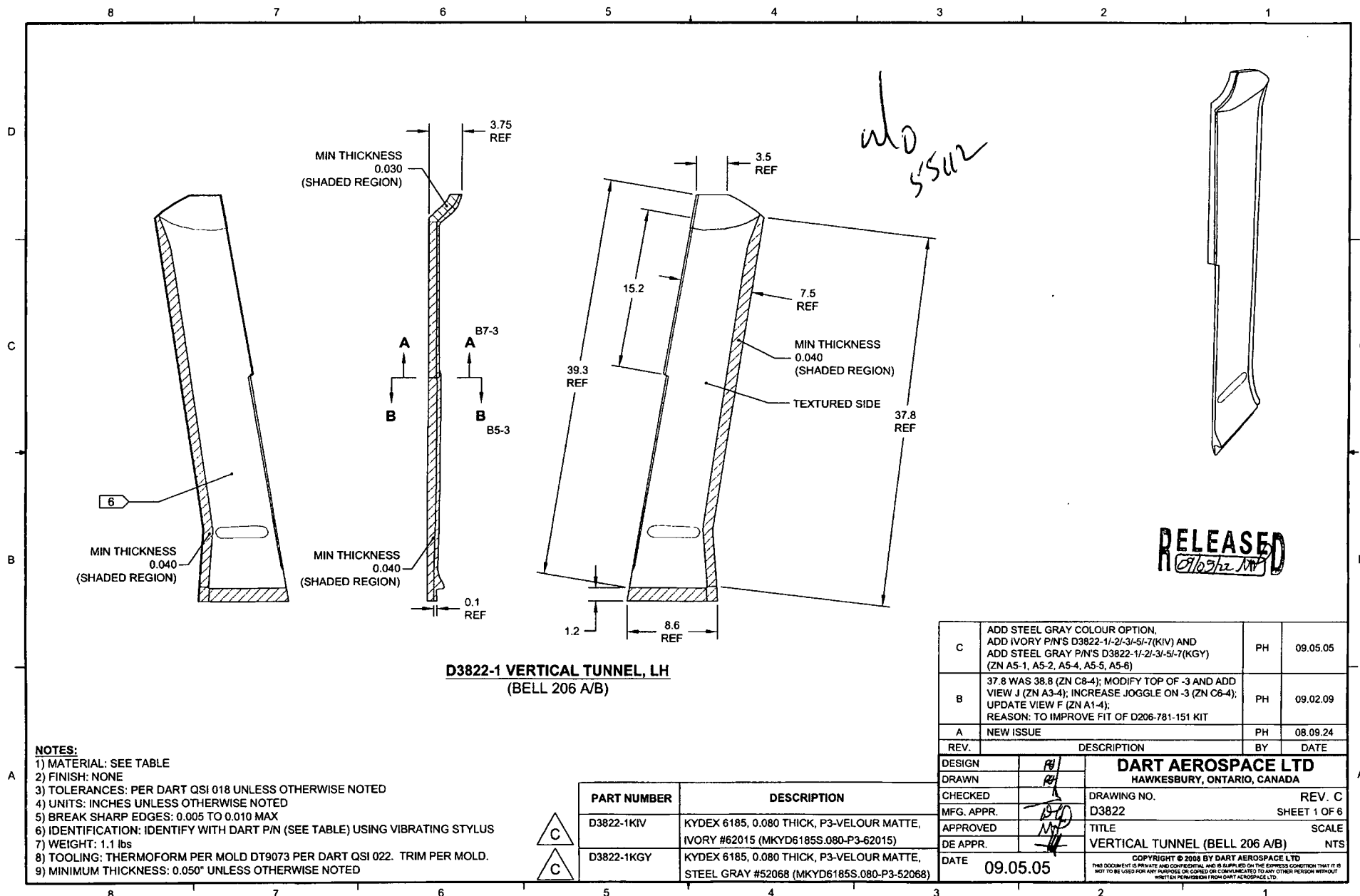
Measured by: DL Date: 10/01/27

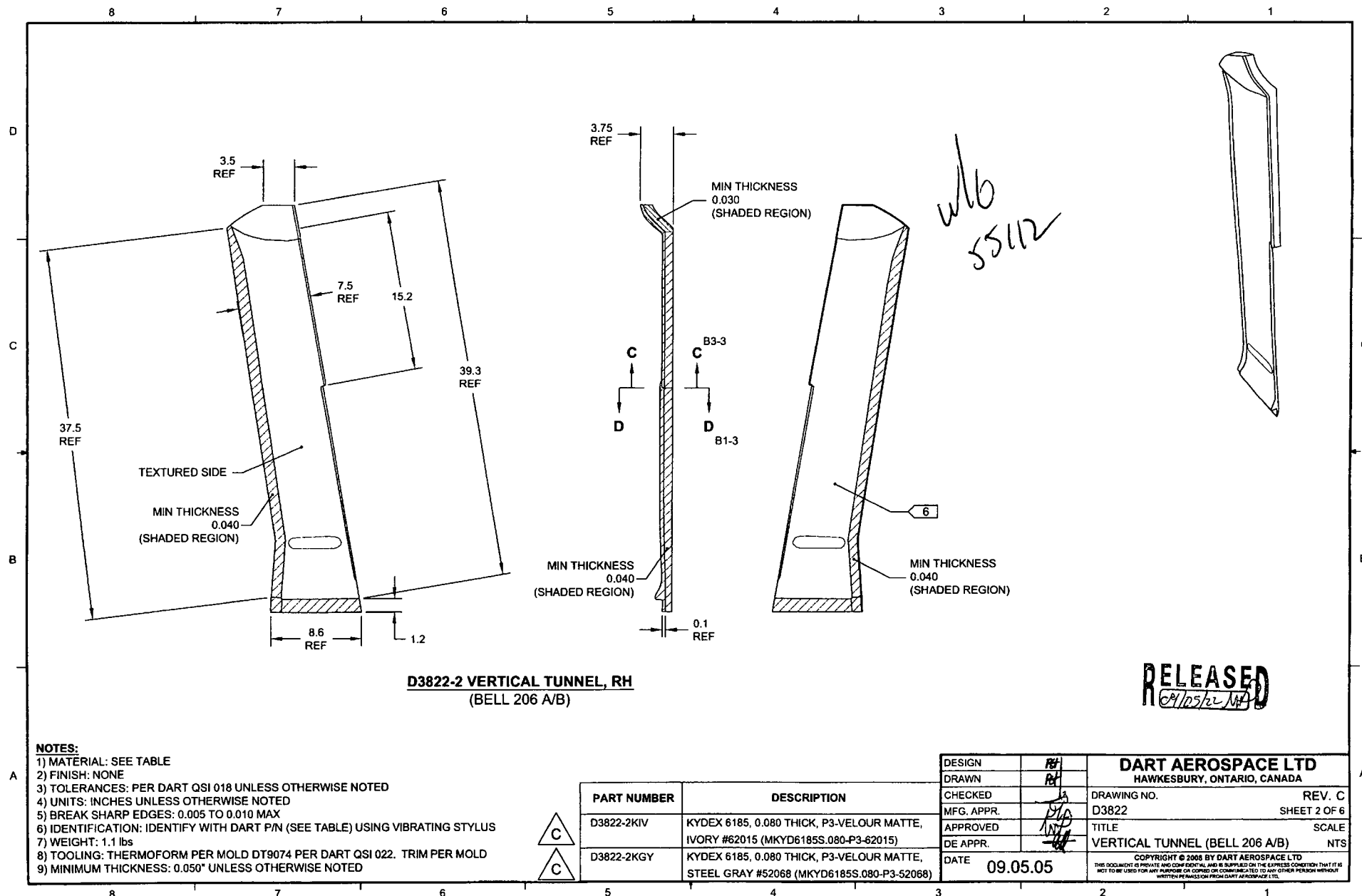
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.062"	✓			
0.020	Min	0.047"	✓			
0.035	Min	0.047"	✓			
0.4	Min	0.419"	✓			

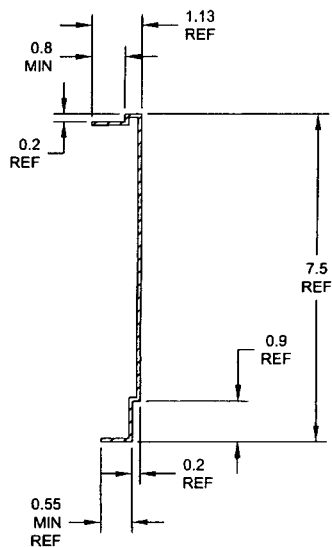
Measured by: DL Date: 10/01/27
Audited by: B Date: 10/01/27
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<u>M</u>

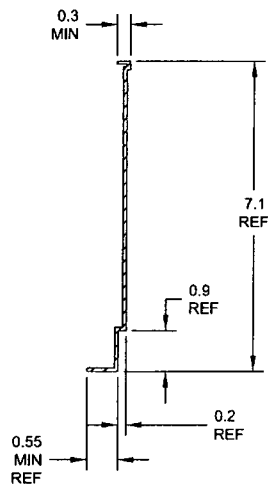




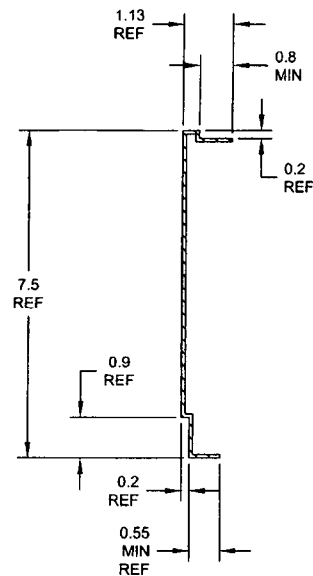
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04/12/2012



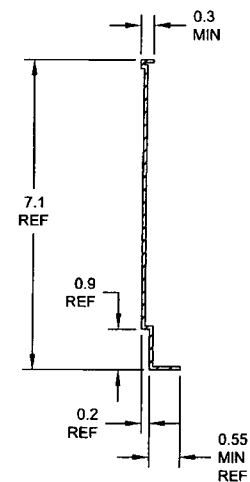
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



SECTION D-D C4-2

RELEASED
09/05/05

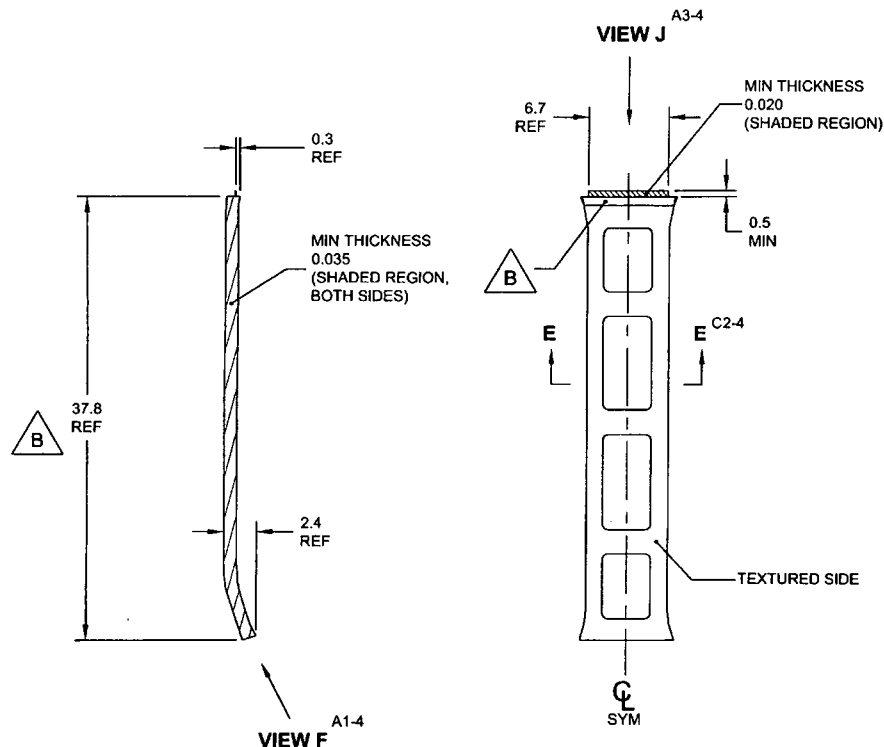
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DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO. D3822	REV. C
MFG. APPR.	RA		SHEET 3 OF 6
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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8 7 6 5 4 3 2 1

D

C

B

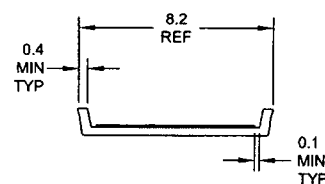


D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

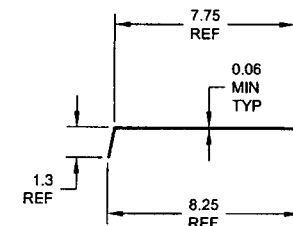
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)



VIEW J
SCALE 2X



VIEW F
SCALE 2X
(ROTATED 90° CW)

RELEASED
09/05/22

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DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED	PA	DRAWING NO. D3822
MFG. APPR.	PA	REV. C
APPROVED	PA	SHEET 4 OF 6
DE APPR.	PA	SCALE
DATE	09.05.05	TITLE
		VERTICAL TUNNEL (BELL 206 A/B)
		NTS

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

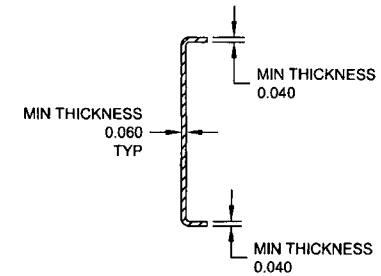
A

D

C

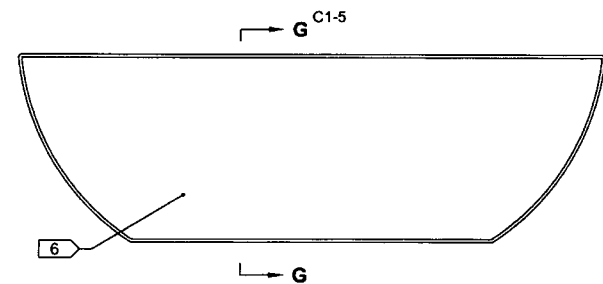
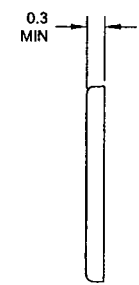
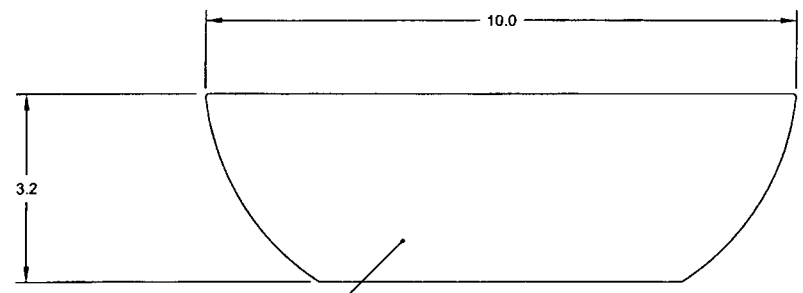
B

A



SECTION G-G C2-5

WV 55112



D3822-5 VERTICAL TUNNEL, TOP
(BELL 206 A/B)

RELEASED
9/25/12 M

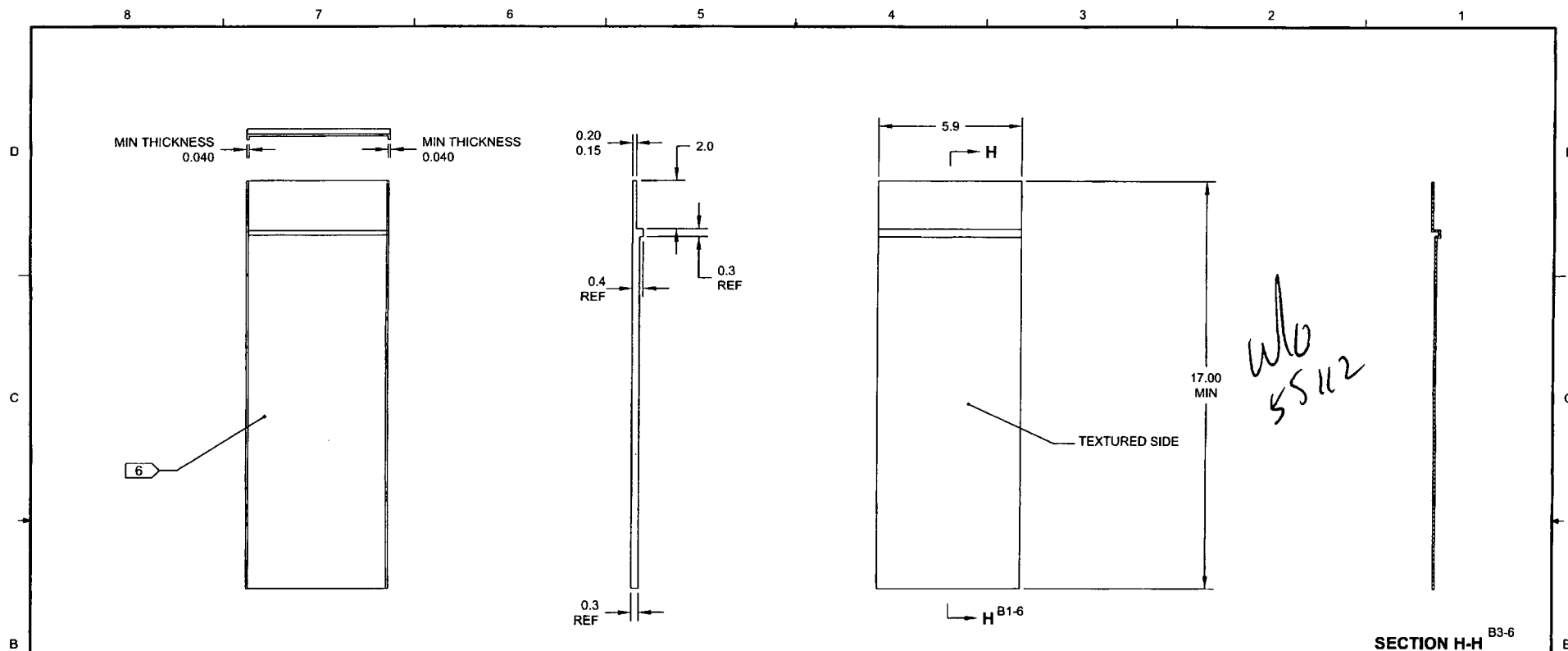
- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.12 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022

C
C

PART NUMBER	DESCRIPTION
D3822-5KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-5KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PM	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO.	REV. C
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APPROVED	PM	TITLE	SCALE
DE APPR.	PM	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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8 7 6 5 4 3 2 1



D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

SECTION H-H B3-6

RELEASED
09/05/05

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
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MFG. APPR.	PA	D3822 SHEET 6 OF 6
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